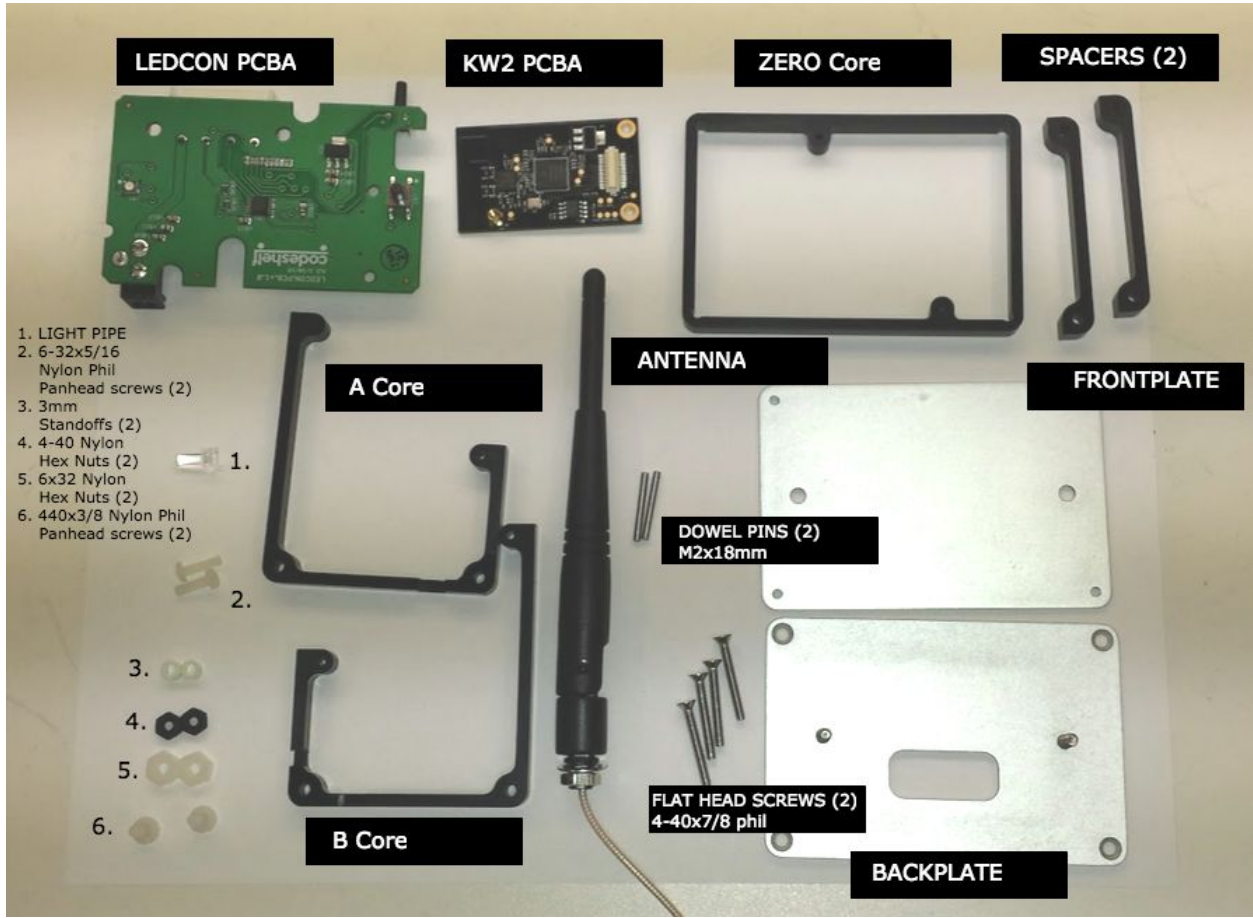


LEDCON.v1.1 Top Level Assembly Document  
October 28, 2015

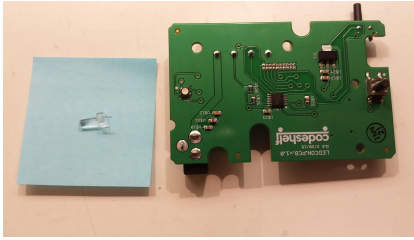


Parts for LEDCON assembly.

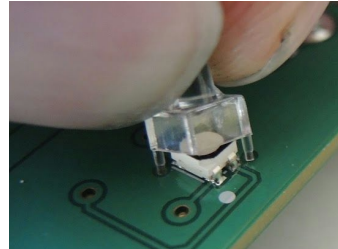
| Part Name in Assembly Document | Part Name in BOM | Part Number     |
|--------------------------------|------------------|-----------------|
| Frontplate                     | Top Coverplate   | LEDCON.FACE     |
| A Core                         | Two Screw Core A | LEDCON.COREBOT  |
| B Core                         | Two Screw Core B | LEDCON.COREBOT  |
| Spacers                        | Two Screw Core C | LEDCON.CORESIDE |
| Zero Core                      | Zero Screw Core  | LEDCON.CORETOP  |

# LEDCON ASSEMBLY INSTRUCTIONS

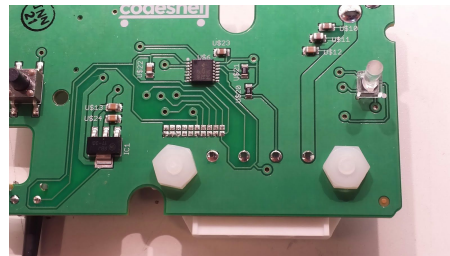
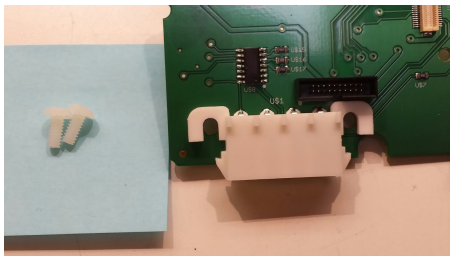
## 1. Mount LIGHT PIPE to LEDCON



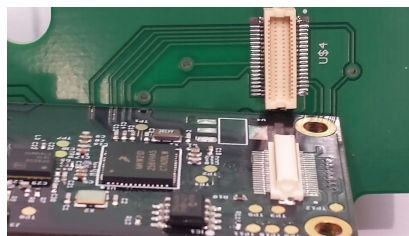
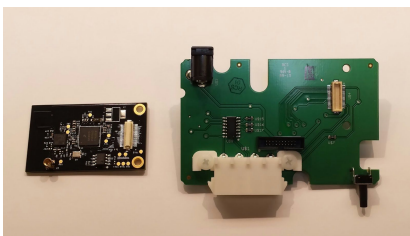
Insert LIGHT PIPE tabs into slots provided over LED.



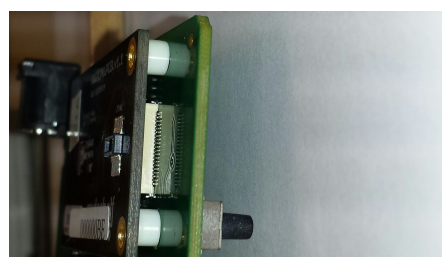
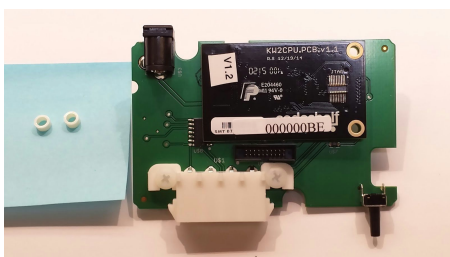
2. Ensure strain relief for LEDCON Cable Connector by inserting two 6-32x5/16 Nylon Phil Panhead screws through loops on the connector and through the associated holes in the LEDCON PCBA. Secure with two 6x32 Nylon Hex Nuts.



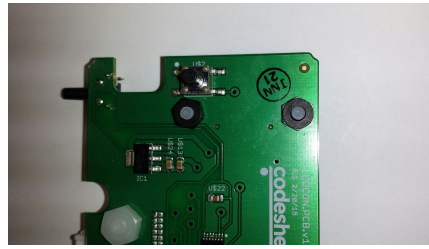
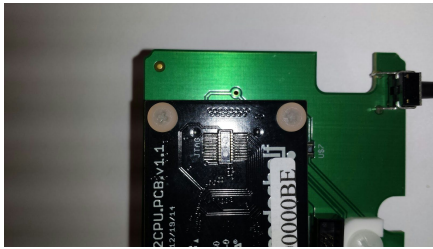
## 3. Attach KW2 PCBA to LEDCON PCBA.



4. Insert two 3mm standoffs between KW2 PCBA and LEDCON PCBA. Align with screw holes in KW2 and POSCON.



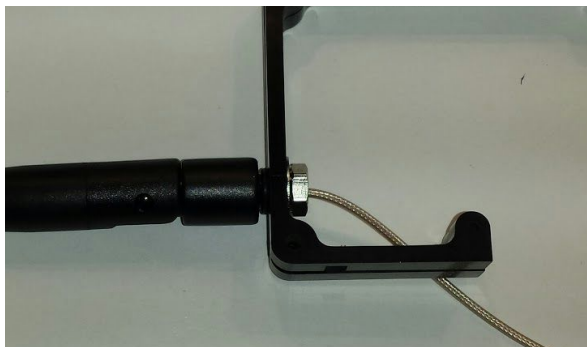
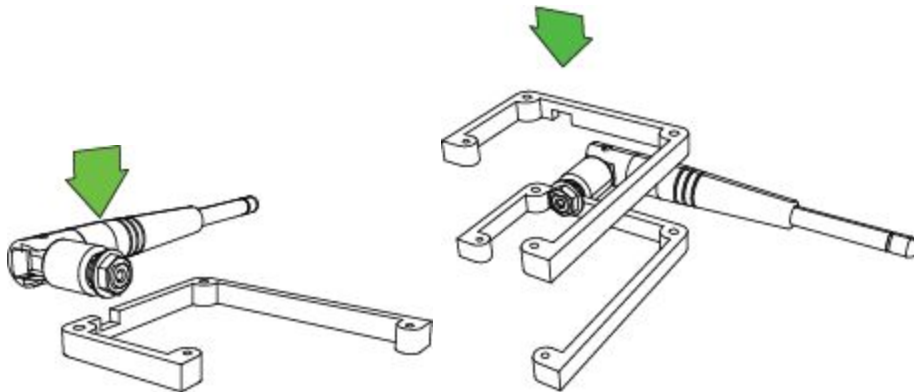
5. Insert two 4-40x3/8 Nylon Phil Panhead Screws through the Standoffs by inserting through the KW2, Standoffs and LEDCON. Secure with 4-40 Nylon hex nuts.



6. Assemble A & B Cores and ANTENNA.

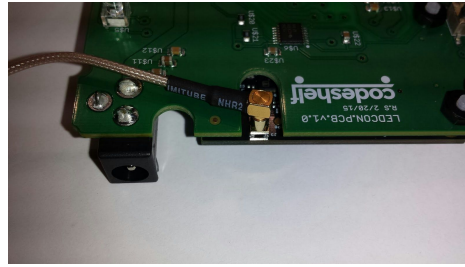
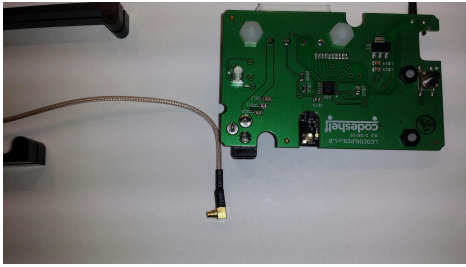
**Remove O ring from Antenna before assembly of A and B cores.**

Lay A Core face up and lay ANTENNA base in notch.

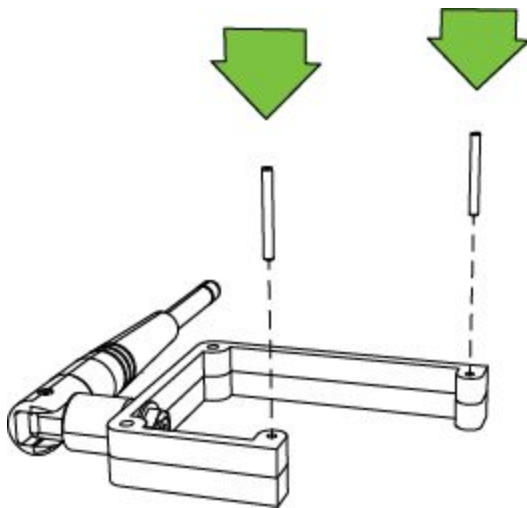
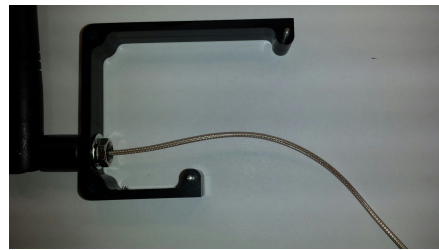


Align notch in B Core with notch in A Core, and place B Core over the exposed base of the ANTENNA. Tighten ANTENNA nut to secure it to both cores. The nut should be tight enough that the antenna remains in position. Be careful not to overtighten the nut and break the Delrin cores, however.

Attach antenna to LED board

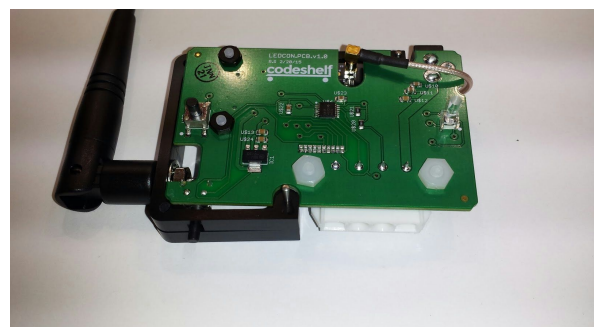


Secure core A & B Cores together with 2 M2x18mm DOWEL PINS



7. Attach KW2/LEDCON Assembly to ANTENNA assembly.

Turn the KW2/LEDCON Assembly so the KW2 faces away and LEDCON Cable Connector is on the bottom.

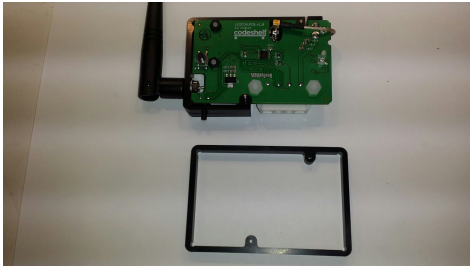




Lay LED board onto ANTENNA Assembly, inserting reset button through hole in bottom of core.

8. Mount ZERO Core on the Assembly.

Align ZERO Core so that its holes align with the DOWEL PINS on the ANTENNA Assembly.

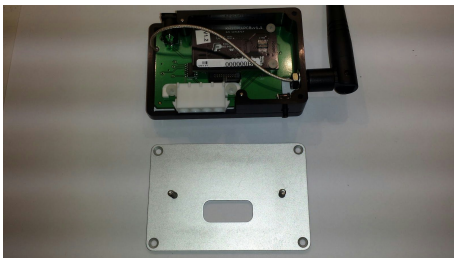


Attach Zero core to A and B cores over dowel pins.

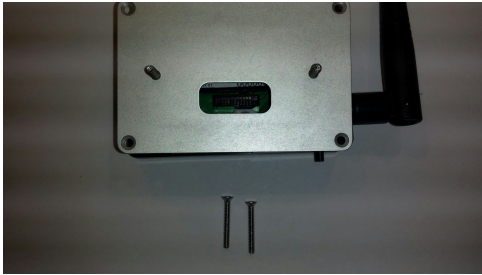
Turn Assembly over.

9. Attach BACKPLATE to Assembly.

With LEDCON Connector facing down and ANTENNA to the right side, align BACKPLATE so that the oblong cutout is toward the bottom of the plate and threaded pins face up.



Lay BACKPLATE onto Assembly. Insert two 4-40x7/8 phil Flat Head screws into the right side of the BACKPLATE and through the corresponding holes in the Assembly.

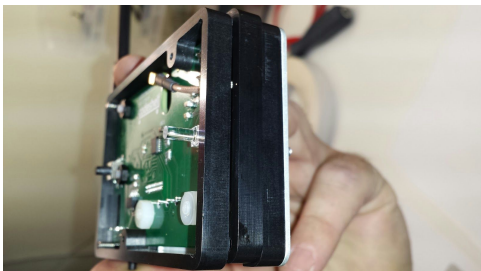


Turn Assembly over.

#### 10. Insert SPACERS.

Lay one SPACER on top of the other SPACER so that they align and flat side faces away from Assembly.

Insert the two SPACERS between the BACKPLATE and ZERO Core.



#### 11. Attach FACEPLATE.

Insert the two remaining 4-40x7/8 phil Flat Head Screws through the BACKPLATE and SPACERS.



Lay FACEPLATE on Assembly so that LIGHT PIPE and Button fit through holes. Attach Faceplate to Assembly by tightening all four 4-40x7/8 screws from the BACKPLATE.

